

Date: Wednesday, 16/07/2008 3:31:37 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT ASS'Y RH		
Job Number	: 40001			Part Number	: D412769044		
Estimate Number	: 13314			Drawing Number	: D412-769-2 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 16/07/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 31/07/2008		
Previous Run	: 40001			Qty:	1	Um:	Each
Written By	<u>J</u>						
Checked & Approved By							
Comment	: Est rev A 08.05.12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 <input checked="" type="checkbox"/> Pick Packing Kit			
2.0	D3782045-	Back Leg Assembly	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Back Leg Assembly batch: <u>B 40 306</u> SB			
3.0	D3782041	Front Inboard Leg Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Inboard Leg Assembly batch: <u>B 40 303</u> SB			
4.0	D3782044	Front Outboard Leg Assembly, RH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Outboard Leg Assembly, RH batch: <u>B 40 305</u> SB			
5.0	D3783041	Lateral Brace Assembly	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lateral Brace Assembly batch: <u>B 40 307</u> SB 08/08/14 (1)			

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-769-044 PAR #: No Fault Category: FAB - Scrapped NCR: Yes No DQA: AS Date: 08.08.21
 QA: N/C Closed: AS Date: 08/08/21

NCR:40001		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/08/21	10	Durding assembly it was found that the D3766-2/1 was drill add. R.C. Drilled by t manually and missed at inspection.	<u>AS/NPZ</u>	Scrap all D3766-2/1 stock (& h ^(x2)) and replace on the a different w/b.	SAM 08/08/13	AS 08/08/13	AS/NPZ 08/08/13	(08/08/13

NOTE: Date & initial all entries

17

Date: Wednesday, 16/07/2008 3:31:37 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	D3783043	Longitudinal Brace Assembly
7.0	D3783045	Angle Brace Assembly
8.0	D3784041	Seat Support Assembly, Center
9.0	D3784043	Seat Support Assembly, LH
10.0	D3784044	Seat Support Assembly, RH
11.0	D37662	Front Rail, RH
12.0	D37663	Rear Rail

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Longitudinal Brace Assembly

batch: B 40308

SB

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Angle Brace Assembly

batch: B 40309

SB

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, Center

batch: B 40659

SB

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, LH

batch: B 40660

SB

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Support Assembly, RH

batch: B 40661

SB

(PJO)

Per. 100% Pass.

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Front Rail

batch: B 40709 B 41218

SB

12.0 D37663

Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rear Rail

batch: B 40710

SB 08/08/08

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 D37671 Upper Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: B4074

SB

14.0 D37921 Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Seat Belt Eye Bolt

batch: B40999

SB

15.0 AN415A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M106077

SM

16.0 AN45 13A EYE BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: M107938

SB

17.0 AN510A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M107534

SB

18.0 AN513A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108167

PTD

SB

19.0 AN960JD10 Washer



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M108558

(or NAS1149D0363J) batch: _____

SM 08/08/08

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector
08/08/14	18	add ANS-13A Bolt M 108 (47) 7 total. update dwg.	SS	08/08/14	5	08.08.14	08.08.14

Part No: D412-169-044 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ff Date: 08.08.14
 QA: N/C Closed: _____ Date: _____

NCR: 40001		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.08.14	18.	Need Qty of 7 ANS-13A. Missing 5 on the Ass'y	08/08/14	update dwg to correct the Qty. See PAR 08-030 to update the Qty.	08/08/14	08/08/14	08/08/14	08.08.14
				RAR cancelled 08.08.21				

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD416	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M 108 166
(or NAS1149D0463J) batch:

SB

21.0	AN960JD516	Washer
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Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M 108 246
(or NAS1149D0568J) batch:

SB

22.0	AN52510R24	Screw
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M 108 270



23.0	MS21042L3	Nut
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M 107 665

SB

24.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M 108 470

SB

25.0	MS21042L5	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M 108 421

SB 08/08/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

SB 08/08/14 (1)

27.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

28.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- Powder coat remainig of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:00

01

OVEN TEMPERATURE: 320

01

FINISH TIME: 1:30

m.k 08/08/14

29.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-14 (X)

30.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

31.0 D37751

Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Guard

batch: M40658

SB 08/08/15 (1)

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action . Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Wednesday, 16/07/2008 3:31:37 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :	
32.0	D37741	Seat Bottom, LH/RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: B40587	SB 08/08/15 /
33.0	D37743	Seat Back, LH/RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Seat Bottom, LH batch: B40588	SB 08/08/15 /
34.0	AN525 10R22	Screw	
		Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Screw batch: M107934	SB 08/08/15 /
35.0	AN960JD10L	Washer	
		Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Washer batch: M105793 (or NAS1149D0332J) batch:	SB 08/08/15 /
36.0	MS21042L3	Nut	
		Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s) Nut batch: M107665	SB 08/08/15 /
37.0	AN35A	Bolt	
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Bolt batch: M100183	SB 08/08/15 /
38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- install remaining parts as per dwg D412-769-2	SB 08/08/15 /

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 40001

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
39.0	QC5	INSPECT WORK TO CURRENT STEP <i>108081500</i>
Comment: INSPECT WORK TO CURRENT STEP		
40.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>(1X)</i>
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: <i>PPD 40573</i> <i>8/8/5</i> <i>SP</i>		
41.0	QC21	FINAL INSPECTION/W/O RELEASE <i>08/08/1998</i>
Comment: FINAL INSPECTION/W/O RELEASE		

Job Completion



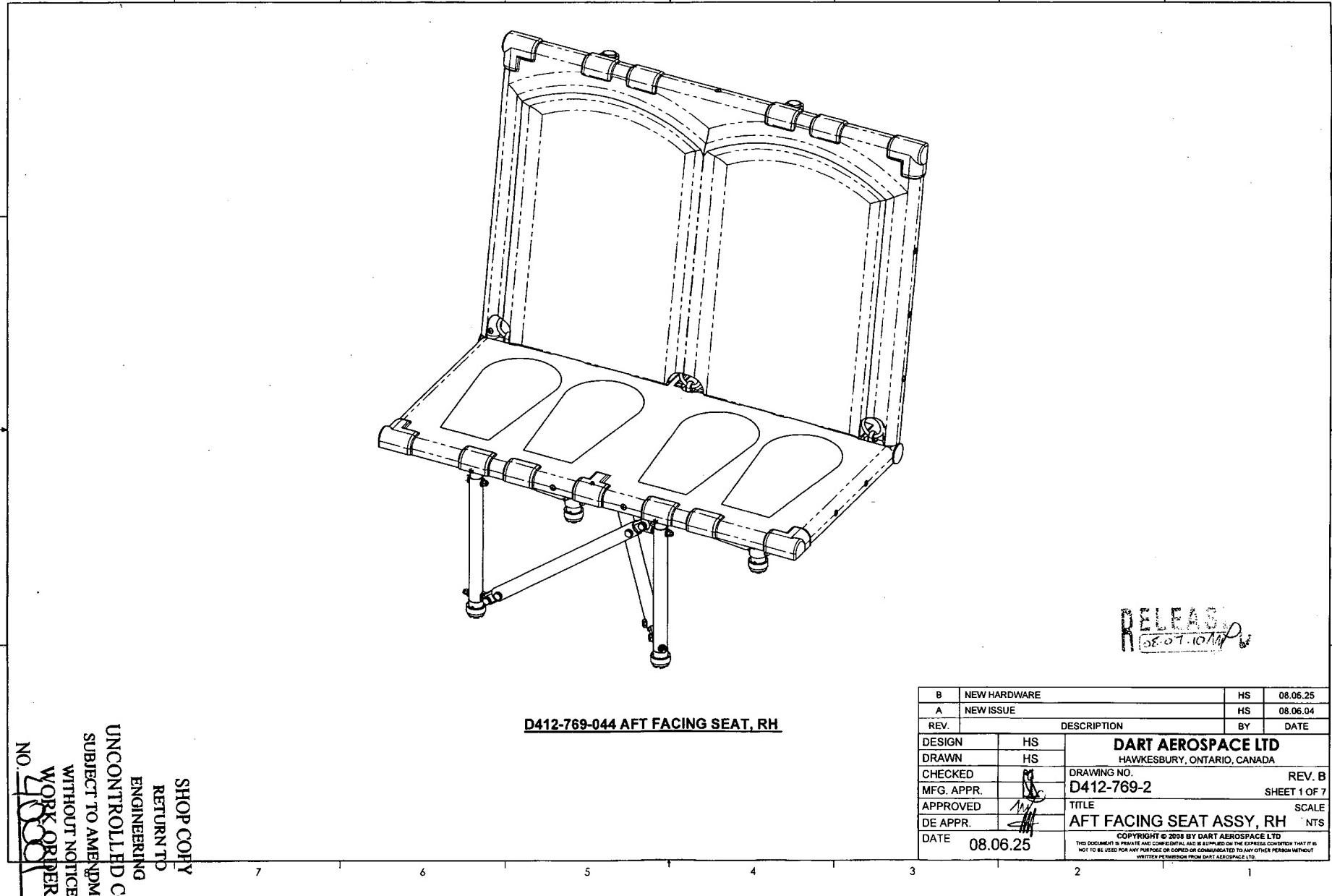
U 8/8/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

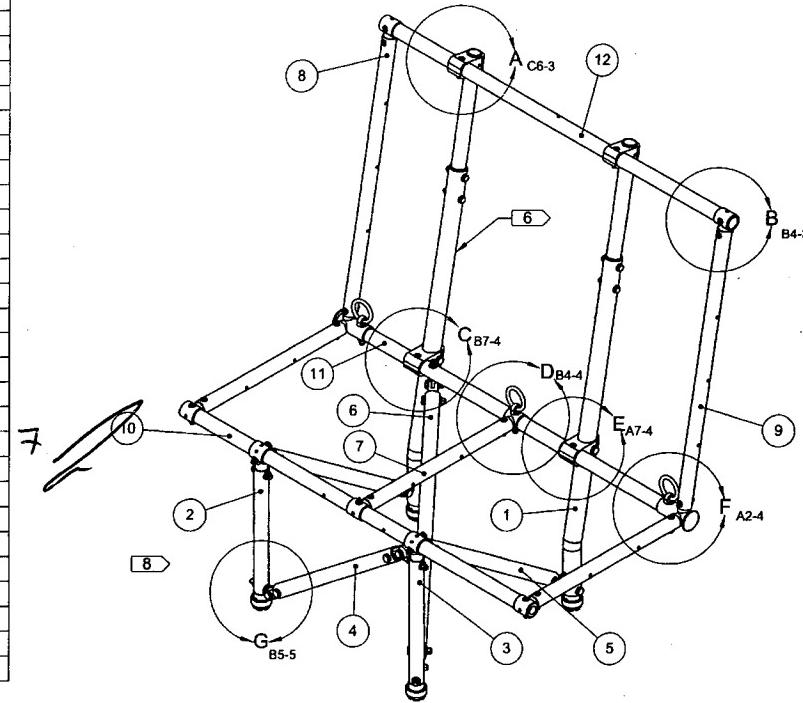
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 7 6 5 4 3 2 1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	ANS-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



D412-769-044 AFT FACING SEAT, RH

RELEASED
08-07-10 MP

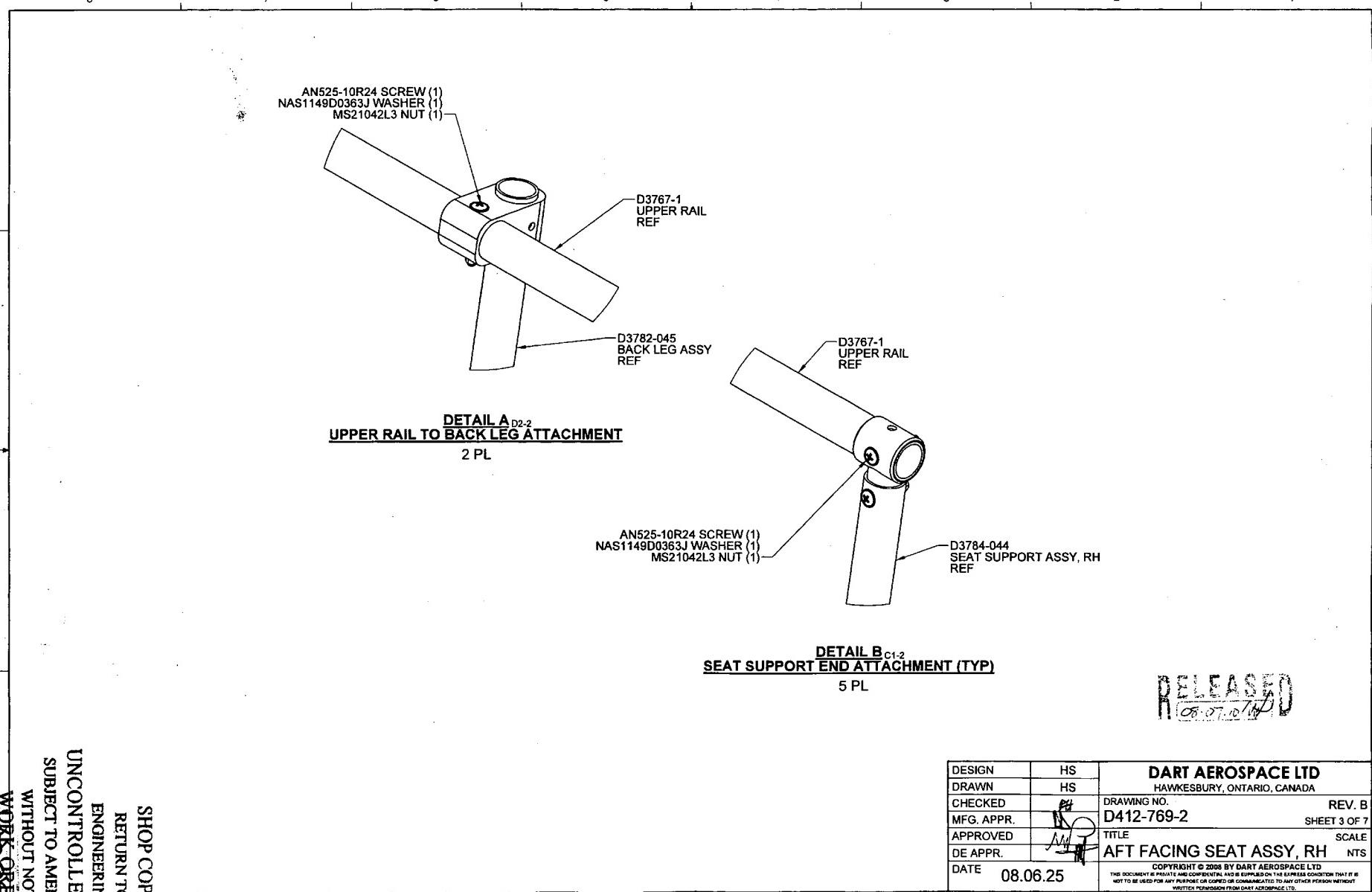
NOTES:

- 1) MATERIAL: N/A
 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
 7) WEIGHT: 30.0 lbs
 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

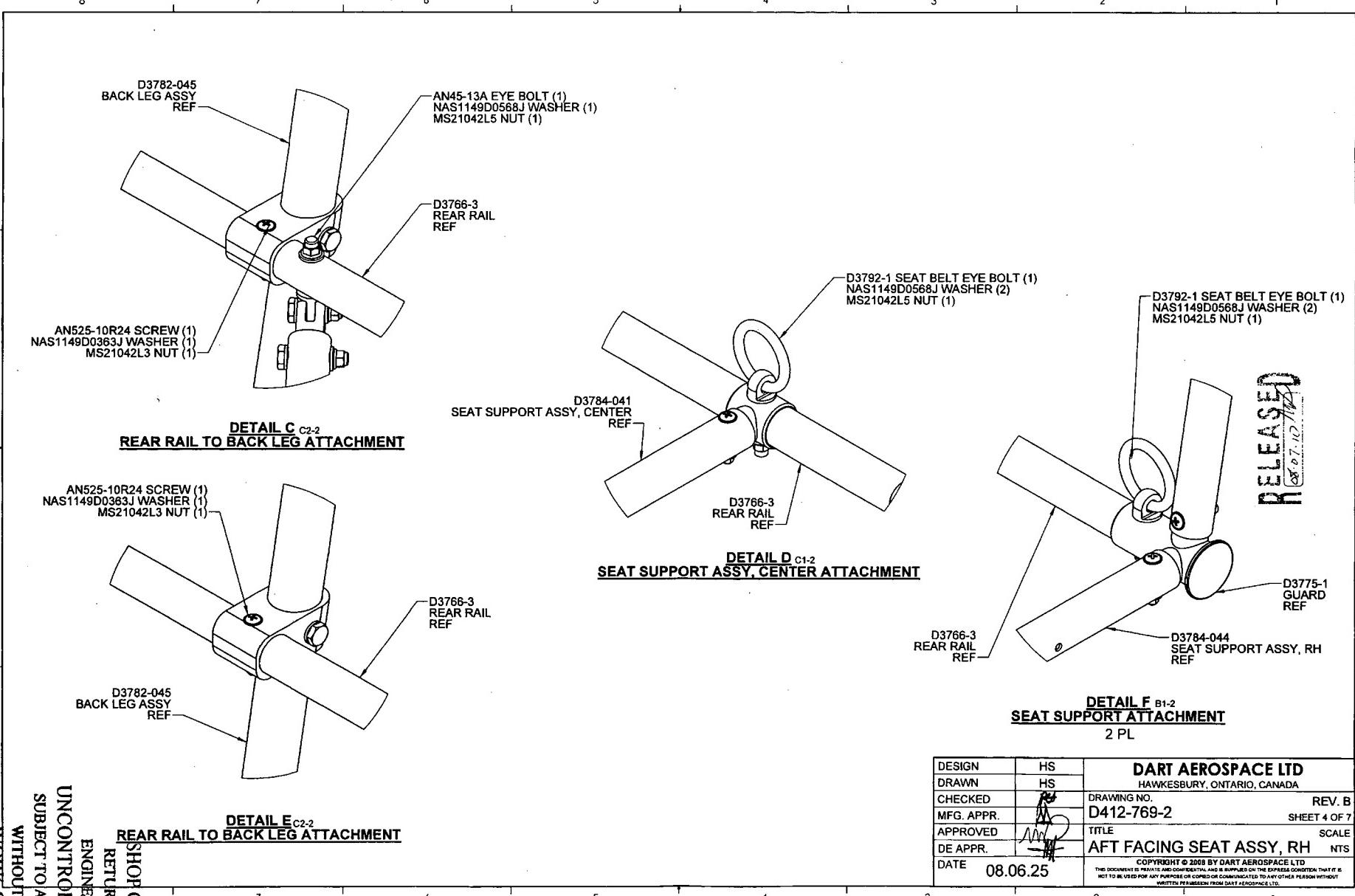
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MFG. APPR.	<i>[initials]</i>	REV. B
APPROVED	<i>[initials]</i>	D412-769-2
DE APPR.	<i>[initials]</i>	SHEET 2 OF 7
DATE	08.06.25	AFT FACING SEAT ASSY, RH
NTS		

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MFG. APPR.	<i>[initials]</i>	D412-769-2	SHEET 4 OF 7
APPROVED	<i>[initials]</i>	TITLE	SCALE
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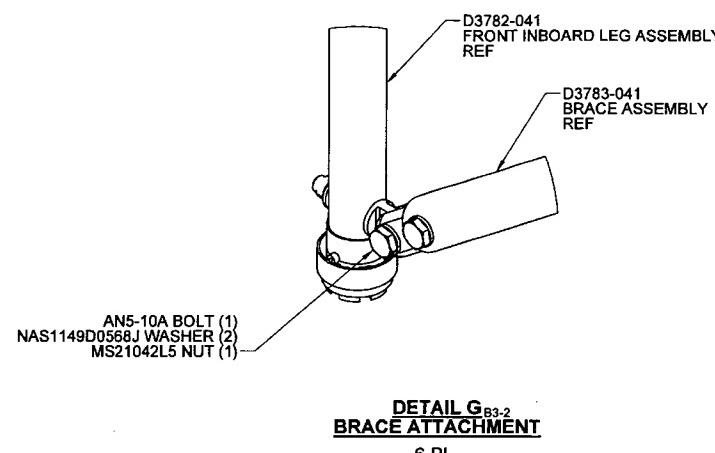
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RELEASED
06-7-10 M

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MFG. APPR.	MA	D412-769-2	REV. B
APPROVED	MM	SHEET 5 OF 7	TITLE
DE APPR.	MM	AFT FACING SEAT ASSY, RH	SCALE NTS
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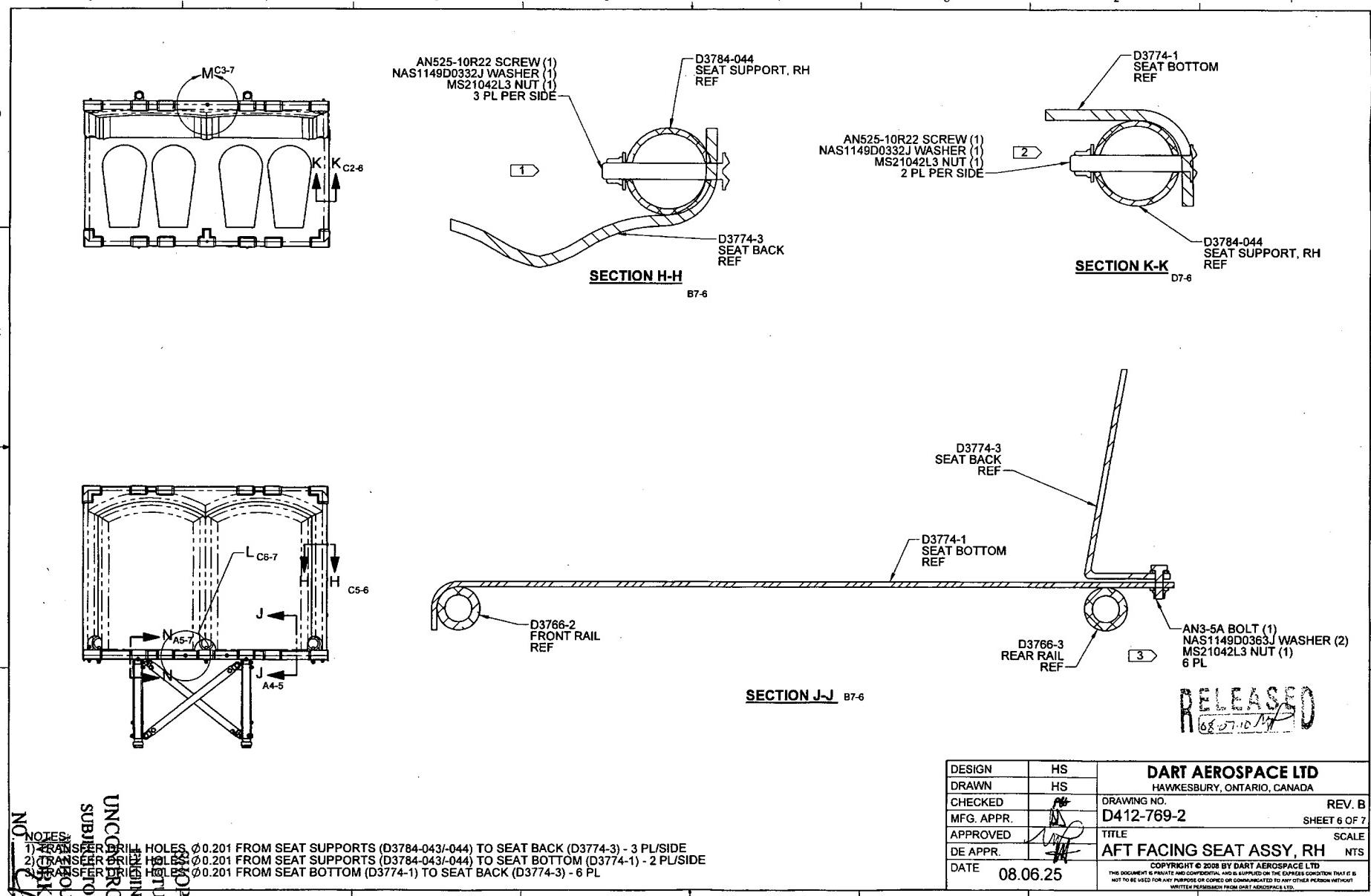
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DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKSLEY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D412-769-2
APPROVED		REV. B
DE APPR.		SHEET 6 OF 7
DATE	08.06.25	TITLE
		AFT FACING SEAT ASSY, RH
		NTS

NOTES:
 1) TRANSFER DRILL HOLES Ø 0.201 FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
 2) TRANSFER DRILL HOLES Ø 0.201 FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
 3) TRANSFER DRILL HOLES Ø 0.201 FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

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